

Date: Thursday, 6/15/2006 1:42:31 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WHEEL ASSEMBLY  
 Job Number : 27570 *slave*  
 Estimate Number : 12102  
 P.O. Number : *N/A* Part Number : D33975  
 This Issue : 6/15/2006 S.O. No. : *N/A* Drawing Number : D3397 REV.A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *N/A* Type : MACHINED PARTS Drawing Revision : A  
 Previous Run : 26774 Material : *N/A*  
 Written By : *[Signature]* Due Date : 7/10/2006 Qty: 12 Um: Each  
 Checked & Approved By : *[Signature]*  
 Comment : est rev. ☒ New issue EC

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1020TR1375W125	COLD DRAWN ROUND TUBE
Comment: Qty.: 0.1313 f(s)/Unit Total : 1.5750 f(s) AISI 1020-1025 ROUND TUBE Dia. 1.375" x 0.125" wall batch: <i>M17015</i> <i>[Signature]</i> 06/07/07		
2.0	LATHE CONV.	CONVENTIONAL LATHE
Comment: CONVENTIONAL LATHE Turn as per Dwg D3397 <i>[Signature]</i> 06/07/10 12		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>[Signature]</i> 06/07/10 12		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <i>[Signature]</i> 06/07/10 12		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>ST434</i> <i>[Signature]</i> 06/07/10 (2)		
6.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL Inspection Level 21 <i>[Signature]</i> 06/07/11 (12)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/07/11

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

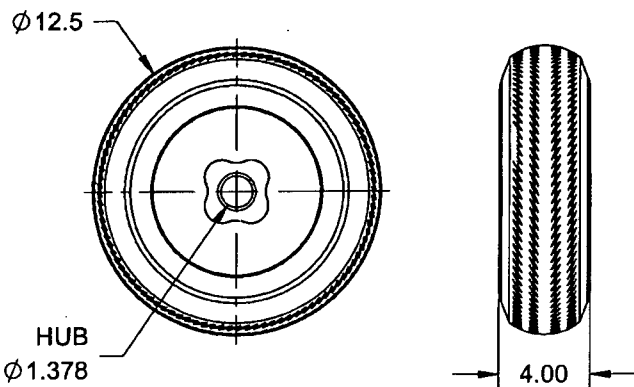
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

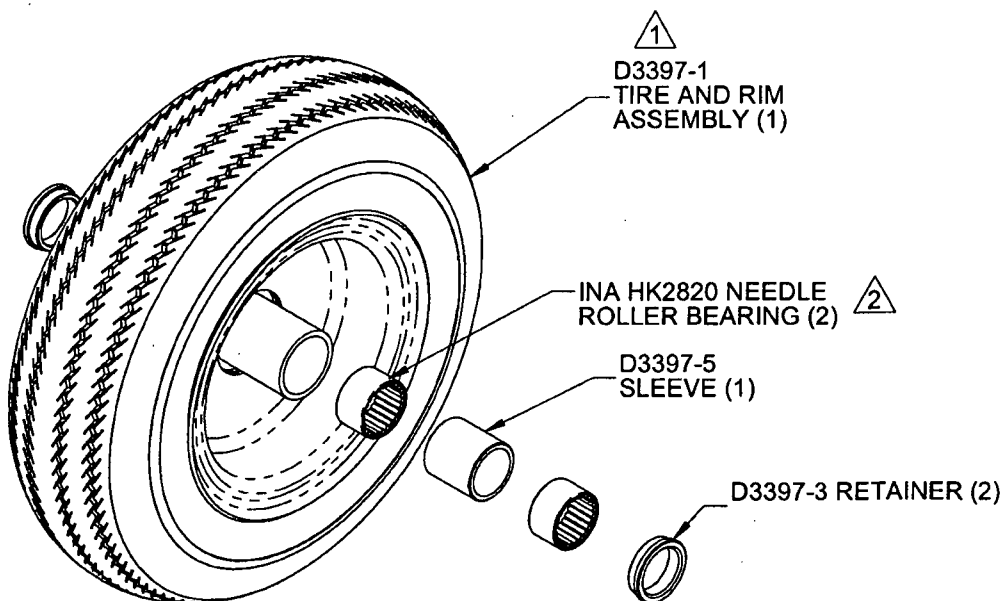
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DATE <b>05.02.10</b>	TITLE <b>WHEEL ASSEMBLY</b>		SCALE 1:8
A	05.02.10	NEW ISSUE	



1 **D3397-1 TIRE AND RIM ASS'Y**

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: $\phi 12.4 \times 4.1$ RIM: $\phi 6.0 \times 4.0$	445 LBS	50 PSI*

**RELEASED**  
06/03/07



**D3397-041 WHEEL ASS'Y**

**NOTES:**

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 4997T28. SCRAP ORIGINAL BEARING
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) INFLATE TIRE TO MAX. 50 psi
- 7) APPLY RUST INHIBITOR NOT PROTECTED BY PAINT. RUST INHIBITOR P/N: LPSC30316

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WORK ORDER

27570

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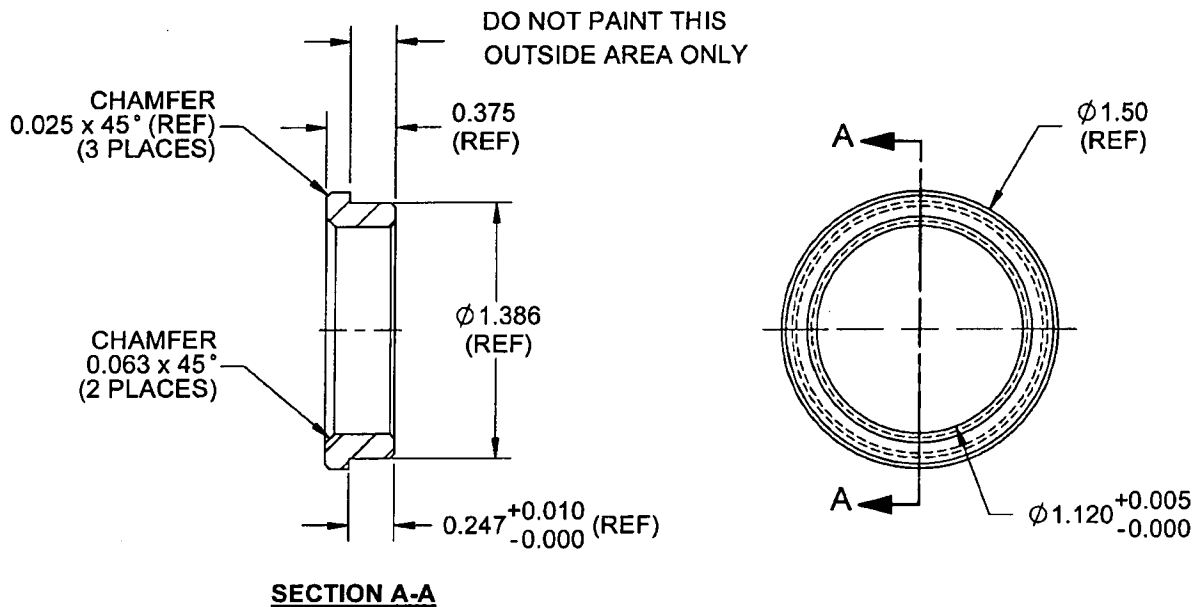
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DATE 05.02.10	TITLE WHEEL ASSEMBLY		SCALE 1:1

**RELEASED**  
*[Signature]* 06/03/09

## SPECIFICATION CONTROL DRAWING



### D3397-3 RETAINER

#### NOTES:

- 1) MATERIAL: REMOVE FROM McMASTER-CARR P/N 4997T28 AND MODIFY AS SHOWN
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.025

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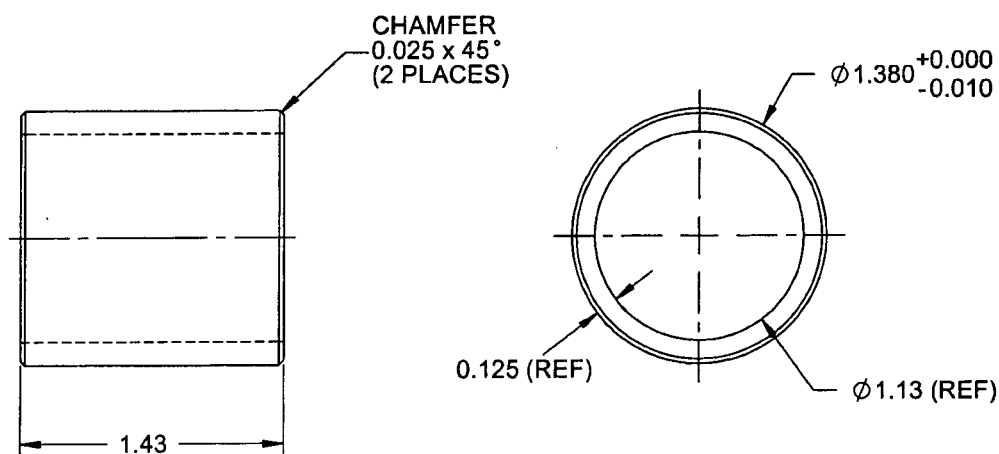
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DATE 05.02.10		TITLE WHEEL ASSEMBLY	SCALE 1:1

RELEASED  
36/02/09



### D3397-5 SLEEVE

#### NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00  
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS  
(REF. DART SPEC. M1020TR1.375W.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.025

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